



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-213
Job Sheet 191148



008447

Part No: D350-591-213

Job Qty: 3 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/22/19

Job Tracking No:

Due Date: 3/11/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *stk*Description: ~~Order 7333~~

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
270	Packaging 1 - Pick Kit	3 pcs		3/11/19	0.00	0.00	Packaging 1 - 1	
							Packaging 1 - 2	
							Packaging 1 - 3	
							Packaging 1 - 4	
							Packaging 1 - 5	
							Packaging 1 - 6	
							Packaging 1 - 7	
							Packaging 1 - 8	
							Packaging 1 - 9	
							Packaging 1 - 10	
							Packaging 1 - 11	
							Packaging 1 - 12	
							Packaging 1 - 13	
							Packaging 1 - 14	
							Packaging 1 - 15	
							Packaging 1 - 16	
							Packaging 1 - 17	
							Packaging 1 - 18	
							Packaging 1 - 19	
							Packaging 1 - 20	
							Packaging 1 - 21	
							Packaging 1 - 22	
							Packaging 1 - 23	
							Packaging 1 - 24	
							Packaging 1 - 25	
							Packaging 1 - 26	
							Packaging 1 - 27	
							Packaging 1 - 28	
							Packaging 1 - 29	

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADATEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S158788

Part: D350-591-213

Job No: 191148

Serial No/Batch: S158788

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92 - 6 Issue 1d as FA

STC SH967NE

MAR 04 2019

					Packaging 1 - 30	
					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
280 QC 4	3 pcs	3/11/19	0.00 0.00		QC 4 - 26	
					QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	MAR 20 2019 9:59 DAS 69
					QC 4 - 9	
					QC 4 - 46	
290 Packaging 3-1 - Stock - B4B	3 pcs	3/11/19	0.00 0.00		Packaging 3 - 1 - B4B	MAR 20 2019 9:59 DAS 69
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	3 pcs	3/11/19	0.00 0.00		DC - 1 - B4B	DAS 21 MAR 20 2019 9:59
					DC - 2 - B4B	
300 QC 21 - FG	3 pcs	3/11/19	0.00 0.00		QC 21 - FG - 21	DAS 21 MAR 20 2019 9:59
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 280 - (QC4- 100% Inspect kits for completeness)
 Descriptions: 290 - Identify and pack for shipping as per PPP D350-591-213

295 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-213 CHG005
 300 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	6 Ea (2 ea)	270-Packaging 1 - Pick Kit	5101329
AN4-15A	Bolt	12 Ea (4 ea)	270-Packaging 1 - Pick Kit	5134436
AN5-36A	Bolt	6 Ea (2 ea)	270-Packaging 1 - Pick Kit	5133174
D2230-3	Mounting Lug	6 pcs (2 ea)	270-Packaging 1 - Pick Kit	5153673
D2618	Bushing	6 pcs (2 ea)	270-Packaging 1 - Pick Kit	5145466
D2732-030	Rubber Cushion - 3"	12 pcs (4 ea)	270-Packaging 1 - Pick Kit	5141533
D3078-041	Step Assembly, Hi Short LH	3 pcs (1 ea)	270-Packaging 1 - Pick Kit	5150059 5159137
D3235-1	Mounting Lug	6 pcs (2 ea)	270-Packaging 1 - Pick Kit	5150059
D3338-1	Mounting Lug	3 pcs (1 ea)	270-Packaging 1 - Pick Kit	5104230
MS21042L3	Nut	6 Ea (2 ea)	270-Packaging 1 - Pick Kit	5150547
MS21042L4	Nut	18 Ea (6 ea)	270-Packaging 1 - Pick Kit	5149814
MS21042L5	Nut	6 Ea (2 ea)	270-Packaging 1 - Pick Kit	5141145
NAS1149D0363J	Washer	12 Ea (4 ea)	270-Packaging 1 - Pick Kit	5123436
NAS1149D0463J	Washer	36 Ea (12 ea)	270-Packaging 1 - Pick Kit	5150216
NAS1149D0563J	Washer	12 Ea (4 ea)	270-Packaging 1 - Pick Kit	5123450
AN4-16A	Bolt	12 Ea (4 ea)	270-Packaging 1 - Pick Kit	5157301

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
270-Packaging 1 - Pick Kit	AN3-35A	6	143	0
	AN4-15A	12	394	0
	AN4-16A	12	213	0
	AN5-36A	6	96	0
	D2230-3	6	94	0
	D2618	6	284	0
	D2732-030	12	494	0
	D3078-041	3	0	0
	D3235-1	6	302	0
	D3338-1	3	64	0
	MS21042L3	6	2,382	0
	MS21042L4	18	2,359	0
	MS21042L5	6	765	0
	NAS1149D0363J	12	1,689	0
	NAS1149D0463J	36	3,253	0
	NAS1149D0563J	12	1,316	0

Part Specifications

Specifications could not be found.

Plex 2/22/19 8:48 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in $\pm$ 1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

Qty -133	Qty -213	Qty -214	Part Number	Description
X			D350-591-133	Heli-Access-Step™, Aft Maintenance Step
	X		D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
		X	D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
1	1	1	D3338-1	MOUNTING LUG (ADD)

4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

Qty -011	Part Number	Description
X	DSI 9712-011	Mounting Lug Kit
1	D3338-1	MOUNTING LUG

5.0 Weight and Balance

There is a negligible weight change associated with this modification.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. Shepherd
D. SHEPHERD (DE # 02)

DATE: 14.12.04
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	MB	14.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>1/1</u>	DART AEROSPACE LTD	
DRAWN	<u>1/1</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>1/1</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9712	SHEET 1 OF 3
APPROVED	<u>1/1</u>	TITLE	SCALE
DE APPR.	<u>1/1</u>	INSTALLATION OPTION	NTS
DATE	14.10.22	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D350-591-213/-213GB/-214/-214GB

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

[illegible]